

Date: Wednesday, 28/05/2008 9:58:05 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 412 X-TUBE INST, LOW NARROW FWD
Job Number : 39535	
Estimate Number : 12816	
P.O. Number :	Part Number : D412664105
This Issue : 28/05/2008 S.O. No. :	Drawing Number : D412-664-145 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : CROSSTUBES	Drawing Revision : C
Previous Run : 39534	Material :
Written By :	Due Date : 02/06/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 08-5-28</u>	
Comment : Est Rev:A New Issue 07-04-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PRP D412-664-105 CHG001

S 08/06/08

2.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

3.0

D412664105TRN

CROSSTUBE TURNING DETAIL

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch 038013

EL 8-5-28

4.0

BENDING

BENDING MACHINE - SKIDTUBES

**Comment:** BENDING MACHINE

Bend tube as per Dwg D412-664-145 using CNC bender program

EL 8-5-28

5.0

QCIS

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

08-05-28 (1)

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1

**Comment:** LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-245

2-Ream hole to finish size in tube as per Dwg D412-664-245

EL 08-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/05/2008 9:58:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE INST, LOW NARROW FWD

Job Number: 39535

Part Number: D412664105

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-245

BT 08.05.29

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube as per QSI 005 4.1

BT 08-05-29

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/05/29 (e)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/29 (e)

10.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 6471 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C208106102 (1)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

P 08/06/2 (1)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

ml 08 06 02

(1)

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 08 06 02 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/05/2008 9:58:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE INST,LOW NARROW FWD

Job Number: 39535

Part Number: D412664105

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 08 06 03

15.0

D31893

Chafing Shield



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Chafing Shield

Batch: 31656

ml 08 06 05

16.0

D3595063450

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rubber Cushion

Batch: 38618

RT 08 06 03

17.0

D28931

2.75 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1 Support 38614

RT 08 06 03

18.0

D2856600

Abrasion Strip



Comment: Qty.: 0.9450 f(s)/Unit Total : 0.9450 f(s)

Abrasion Strip

1X D2856 .250" X 8.42"

Batch: 35900

ml 08 06 05

19.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 107441

ml 08 06 05

20.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: 107973

RT 08 06 03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Wednesday, 28/05/2008 9:58:06 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE INST,LOW NARROW FWD

Job Number: 39535

Part Number: D412664105

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-145

1-Install Chaffing Shield

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3-Instal supports with magnobond 6398 per dwg D412-664-245,
cure for 12hrs before packaging.

Time & date of application: 230 0806-03

Batch: 107621

ml
080605 (1)

ET 08-06-03

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/05 (40)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M67778

AS 08/06/05 (40)

25.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M67534

AS 08/06/05 (40)

26.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

Batch: M105077

AS 08/06/05 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/05/2008 9:58:06 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE INST,LOW NARROW FWD

Job Number: 39535

Part Number: D412664105

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch: M167242

SS 08/06/05 (4)

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508106105 (20)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-105

for Draft

8/6/5

(1x)

STP

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208106106

Job Completion



umf 08-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 39535
Description: Crosstube Assembly (412 Low Narrow Fwd)	Part Number: D412-664-145
Inspection Dwg: D412-664-145 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

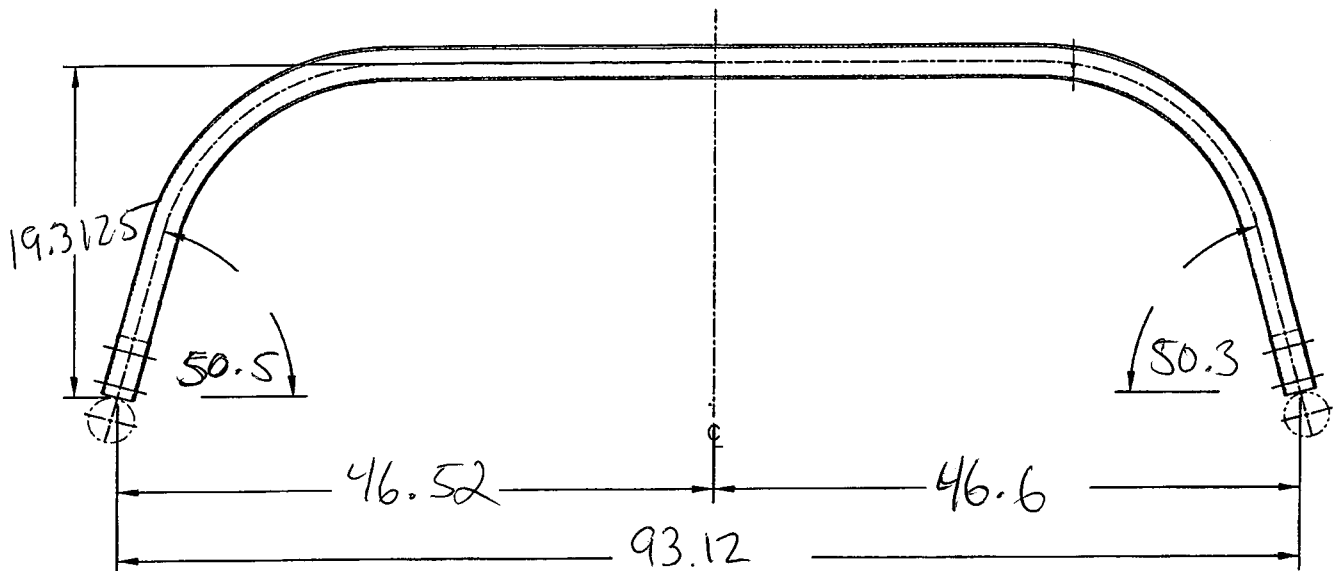
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.740	+0.005/-0.000				
	2.490	+0.005/-0.000				
	2.557	+0.005/-0.000				
	2.624	+0.005/-0.000				
	2.692	+0.005/-0.000				
SIDE B	2.740	+0.005/-0.000				
	2.490	+0.005/-0.000				
	2.557	+0.005/-0.000				
	2.624	+0.005/-0.000				
	2.692	+0.005/-0.000				
	124.48	+/-0.020				

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

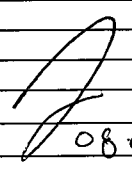
Rev	Date	Change	Revised by	Approved
A	08.04.21	New Issue (P/O D412-664-105)	KJ/DD	

DART AEROSPACE LTD		Work Order: 39535
Description: Crosstube Low Narrow Fwd (412)		Part Number: D412-664-105
Inspection Dwg: D412-664-145 Rev: C		Page 1 of 1


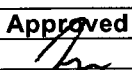
Required Dimension	Min	Max
Height	19.23	19.49
1/2 Span	46.47	46.73
Angle	49°	52°
Total Span	92.94	93.46



Comments

QC15 Inspection	
Date	

0805.28

Rev	Date	Change	Revised by	Approved
A	07.04.27	New Issue	KJ/JM 	

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D412-664-145	REV. C SHEET 1 OF 3
DATE 07.03.29		TITLE CROSSTUBE ASS'Y (412 LOW-N FWD) NTS	
A	06.12.21	NEW ISSUE	
B	07.03.01	CHG RUBBER CUSHION	
C	07.03.29	CHG CLAMP & RUBBER CUSHION LGTH.	

RELEASED07.04.24 *HH***PARTS LIST:**

Qty	Part Number	Description
X	D412-664-145	CROSSTUBE ASSEMBLY (412 LOW-NARROW FWD)
1	D6019-128	CROSSTUBE
1	D2856-250-842	ABRASION STRIP
2	D2893-1	SUPPORT
1	D3189-3	CHAFING SHIELD
4	D3595-063-450	RUBBER CUSHION
2	MS21920-24	CLAMP
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

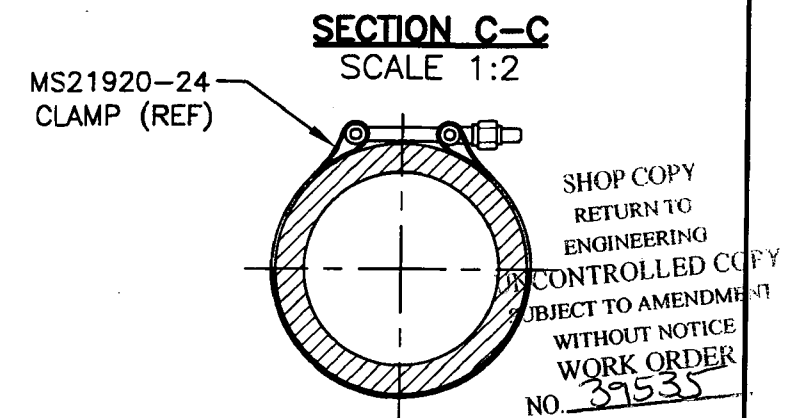
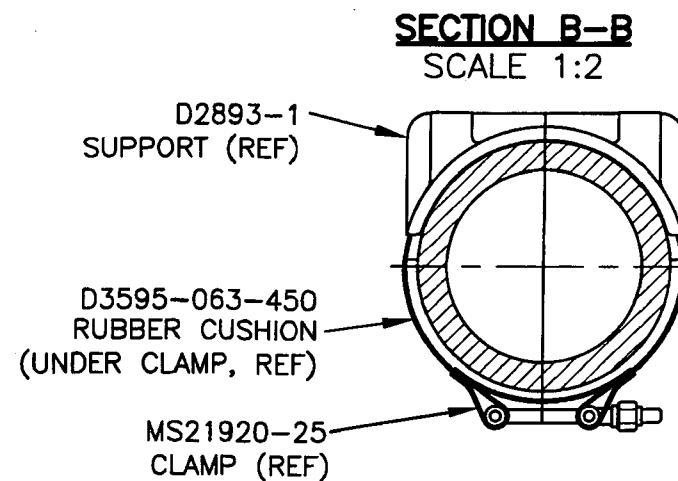
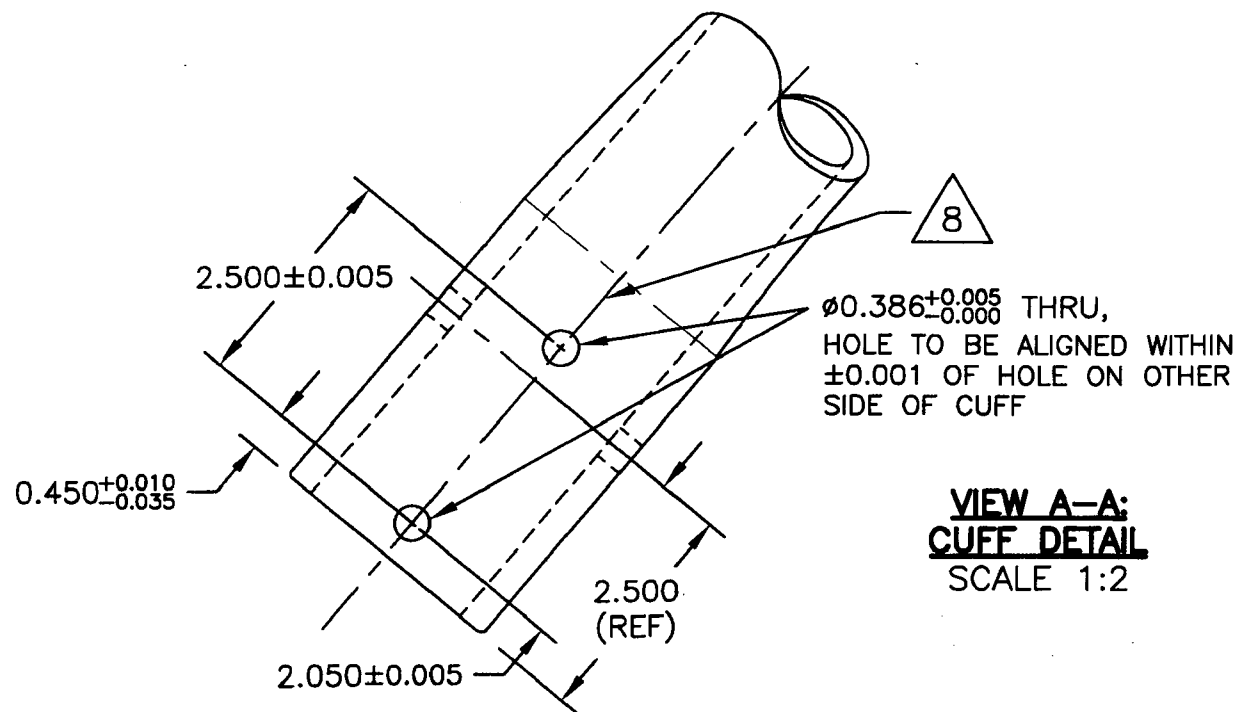
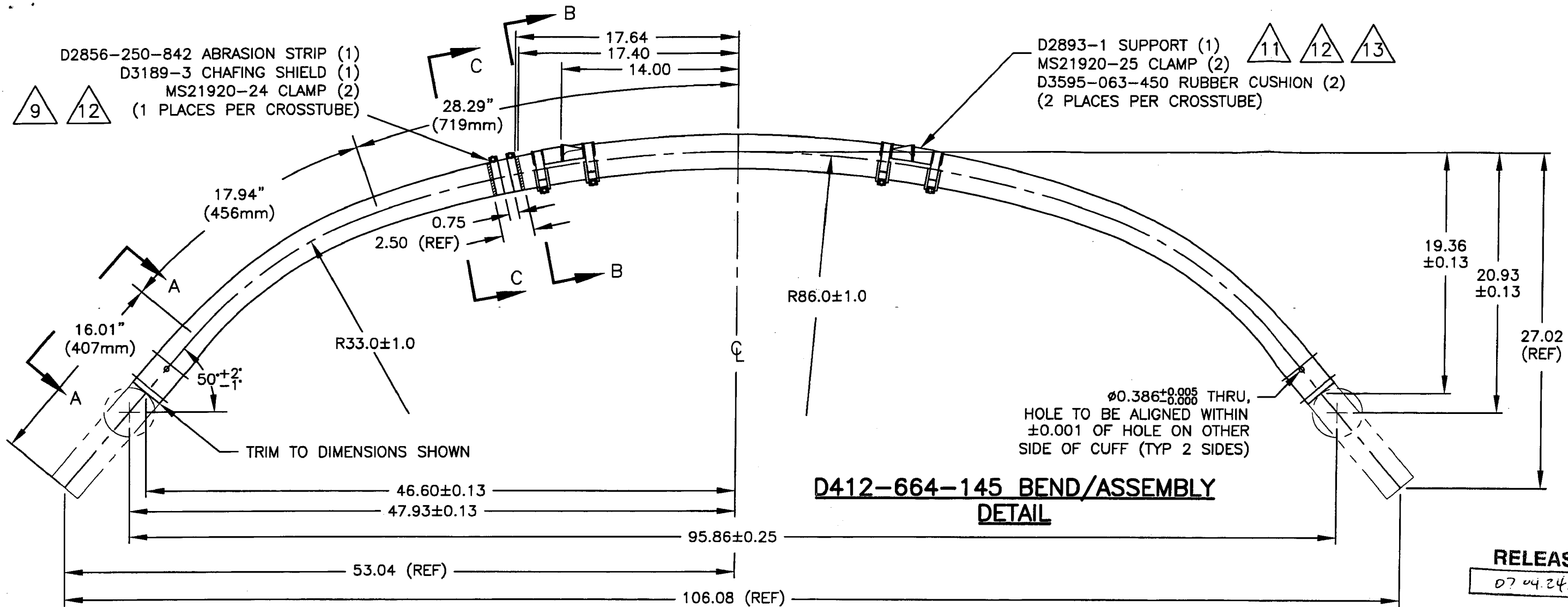
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6019-128
FINISHED LENGTH = 124.48 ± 0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR D3189-3 CHAFING SHIELD AND ASSOCIATED HARDWARE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-XXX-YYY ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

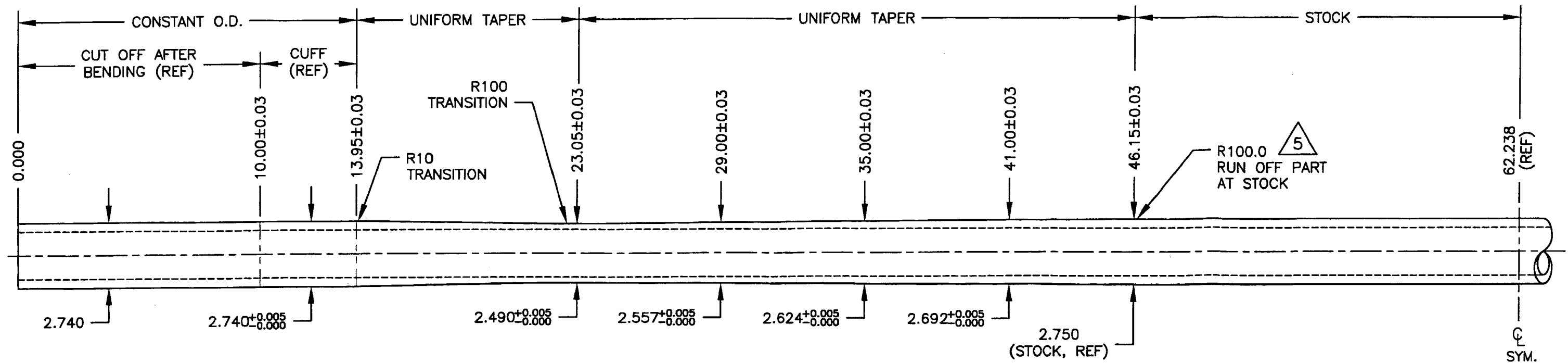
SHOP COPY
RETURN TOUNCONTROLLED COPY
SUBJECT TO AMENDMENTWORK ORDER
NO. 39535

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COPYRIGHT © 2006 BY DART AEROSPACE LTD.		DESIGN 92	DRAWN BY 92	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED 11	APPROVED 11	DRAWING NO. D412-664-145	REV. C SHEET 2 OF 3
DATE 07.03.29		TITLE CROSSTUBE (412 LOW-NARROW FWD)		SCALE 1:8	



D412-664-145 MACHINING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39535

RELEASED

07.04.19

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DART AEROSPACE LTD.

DESIGN

DRAWN BY

DART

DART AEROSPACE LTD.
HAMKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

D412-664-145

REV. C

SHEET 3 OF 3

DATE

07.03.29

TITLE

CROSSTUBE (412 LOW-NARROW FWD) 1:4



LIQUID PENETRANT TEST REPORT

P - 1311 1

CLIENT	DART AEROSPACE	DATE	MAY 30, 2008	PAGE	1	OF	1
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 08 1311	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST	PO/NO No.	6471				
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY				
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
PROJECT	412 HIGH AFT X TUBE, 212/205 HIGH AFT X TUBE, 412 LOW NARROW FWD X TUBE,						
ITEM(S) EXAMINED	JOB #S 412-39111, 39534, 39535, 212/205-39367, 39368.						

JOB DESCRIPTION	PROCEDURE NO. LT-0002	REV./DATE	TECHNIQUE NO. LT-TECH2	REV./DATE
'PART NO.	D412664203/D212664201/D412664105		MATERIAL	ALODINED ALUM.
SCOPE	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE			

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL MAY 1 08	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL
SURFACE ON:

212/205 HIGH AFT X TUBE JOB#: 39367, 39368.

412 HIGH AFT X TUBE JOB#: 39111.

412 LOW NARROW FWD X TUBE JOB#: 39534, 39535.

RESULTS: NO INDICATION OF DEFECTS.
ITEMS ACCEPTABLE TO STANDARD

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE		DTR # E 19676
TECHNICIAN (SIGNATURE):		REPORT REVIEWED BY:
NAME (PRINT):	JASON HEWETT	NAME INITIALS
	1 ST TECHNICIAN	
CGSB LEVEL	2 SNT LEVEL	CGSB LEVEL SNT LEVEL
CGSB REG. No	6156	CGSB REG. No

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

Date: Wednesday, 28/05/2008 9:58:05 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 412 X-TUBE INST,LOW NARROW FWD
Job Number : 39535	
Estimate Number : 12816	
P.O. Number :	Part Number : D412664105
This Issue : 28/05/2008 S.O. No. :	Drawing Number : D412-664-145 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : CROSSTUBES	Drawing Revision : C
Previous Run : 39534	Material :
Written By :	Due Date : 02/06/2008 Qty: 1 Um: Each
Checked & Approved By : JLD 08.5.28	
Comment : Est Rev:A New Issue 07-04-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Photocopy bluefile and create labels as per PPP D412-664-105 CHG001

JLD 08.5.29

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

3.0	D412664105TRN	CROSSTUBE TURNING DETAIL
-----	---------------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 CROSSTUBE TURNING DETAIL
 batch _____

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



Comment: BENDING MACHINE
 Bend tube as per Dwg D412-664-145 using CNC bender program

5.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

6.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-245

2-Ream hole to finish size in tube as per Dwg D412-664-245